

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009562**Date Inspected:** 13-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Chuan Ging , Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower/OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY #10

This QA Inspector randomly observed the following work in progress.

SOUTH TOWER LIFT # 4

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 053116 performing Flux Core Arc Welding process for the weld joint SSTL4-1K/L -80 located on PCMK South tower lift #4. ZPMC QC Mr. Li Peng Fei monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054069 performing Flux Core Arc Welding process for the weld joint SSTL4-1J/L -81 located on PCMK South tower lift #4. ZPMC QC Mr. Li Peng Fei monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040533 performing Flux Core Arc

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Welding process for the weld joint SSTL4-1F/L -84 located on PCMK South tower lift #4. ZPMC QC Mr. Sun Tian Liang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 057244 performing Flux Core Arc Welding process for the weld joint SSTL4-1H/L -132 located on PCMK South tower lift #4. ZPMC QC Mr. Sun Tian Liang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 053870 performing Flux Core Arc Welding process for the weld joint SSTL4-1G/L -86 located on PCMK South tower lift #4. ZPMC QC Mr. Sun Tian Liang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 1AAW- 1AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 049769 performing Shielded Metal Arc Welding process for the base metal repair located on PCMK bottom panel of OBG segment 1AW approximately 700mm from counter weight side and 3015mm from bottom panel splice joint between OBG segment 1AW and 1AAW. ZPMC QC Mr. Feng Yang Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) Repair-1. The critical weld repair report identified as B-CWR816.

OBG SEGMENT 1AW- 1BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054467 performing Shielded Metal Arc Welding process for the weld joint OBW1-006 on the excavated areas located on PCMK deck panel splice weld joint between of OBG segment 1AW and 1BW. The Y location measured approximately 2240mm and 3500mm from cross beam side. ZPMC QC Mr. Feng Yang Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) Repair-1. The critical weld repair report identified as B-CWR819.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054467 performing Shielded Metal Arc Welding process for the weld joint OBWA-009 on the excavated areas located on PCMK side panel splice weld joint between of OBG segment 1AW and 1BW cross beam side. The Y location measured approximately 2400mm from bottom panel towards edge panel. ZPMC QC Mr. Feng Yang Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (4F) Repair-1. The weld repair report identified as B-WR7254.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant
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Quality Assurance Inspector

Reviewed By:	Dawson,Paul
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QA Reviewer
